

Work Order ID 64980

Page 1

Wednesday, January 05, 2011 12:50:29 PM

Item ID: D412-742-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Float Skidtube

Start Date: 1/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

1-01-5

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3391

Rev H

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

If D412-742-043 is a W/O on it's own,
Photocopy bluefile and create labels per PPP D412-742-043 CHG004

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Start Date: 1/5/2011 Start Qty: 1.00



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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00



HandFinishing

HandFinish

Memo

0.00

Hand Finishing

1-Install tubes together and seal them all the way around using Sikaflex
241/291. Ensure tube ends line-up with saddle holes for proper alignment. using
7/16" "T" Pins.

✓ A/R ☐ Sikaflex-241/-291 ☐ 11116945
Expiry date: ☐ 12/01

2-Install wearplates as per Dwg D3391. Ensure that plastic washers are against
wearplate, then topped with the SS washer. Seal all bolts with sikaflex except
✓ ones with inserts on inside of tube, hand tighten only bolts with no sikaflex.

✓ A/R ☐ Sikaflex-241/-291 ☐ 11116945
Expiry date: ☐ 12/01

3-Remove "T" pins once sikaflex is dry.

4-Coat all exposed hardware with LPS Procyon. Remove any excess off with
MEK degreaser.

✓ A/R ☐ LPS Procyon ☐ 11114596

1 d 24 1/05/21

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Start Date: 1/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 1/14/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



8 w/lost 24

QC

Memo

0.00

50

Quality Control

130

Packaging

0.00



0.00

Packaging

Memo

Packaging

Identify and pack for shipping as per PPP D412-742-043

Location: _____

PPP Rev: _____

PM 69240

P240/300

140

QC21- Final Inspection - Work Order Release

0.00



0.00

QC

Memo

Quality Control

11/5/31 JF
ME
11-05-30

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Wednesday, January 05, 2011 12:51:25 PM

[illegible]

Required Qty: 1.00

Comments: IPP Rev A 05.10.13 New Issue KJ/JLM
 IPP Rev B 06.02.13 ECN 773 dwg @ rev.D EC
 IPP Rev:C 07-05-28 As per Rev F JLM
 IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM
 IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A 		Purchased	No			110	Each	1,333.000	24	24			
BOLT													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST350		1333		M117313		x24			
				115300		29							
				115936		304							
				116075		1000							
AN3C6A 		Purchased	No			110	Each	241.0000	12	12			
BOLT													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		241		M116704		x12			
				111982		166							
				116419		75							
AN3C7A 		Purchased	No			110	Each	166.0000	8	8			
BOLT													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		166		M116876		x8			
				113149		73							
				114382		10		117619					
				116169		83							

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 05, 2011 12:51:25 PM

Page 2

Work Order ID: 64980

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

110 Each 25.0000 44 44



washer



sl ulos/zo

Location

Loc Qty

Loc Code

ST245

25

107534

25

1117291

x44

D3391-021 Manufactured No

110 Each 0.0000 1 1



Fwd Tube Assembly



B66302(x1) sl ulos/zo

D3391-023 Manufactured No

110 Each 1.0000 1 1



Mid Tube Assembly



B68680(x1) sl ulos/zo

Location

Loc Qty

Loc Code

FP

1

40522

1

D3391-025 Manufactured No

110 Each 1.0000 1 1



Aft Tube Assembly



B68649(x1) sl ulos/zo

Location

Loc Qty

Loc Code

FP

1

48122

1

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Wednesday, January 05, 2011 12:51:25 PM

Page 3

Work Order ID: 64980

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-1

Manufactured No

110 Each

19.0000

1

1



jsl 11/05/20

Wearshoe

Location

Loc Qty

Loc Code

FG

2

33798

2

FP019

14

64747

14

yl

FP19

3

58823

3

D3564-3

Manufactured No

110 Each

21.0000

1

1



jsl 11/05/20

Wearshoe

Location

Loc Qty

Loc Code

FG

2

33764

2

FP019

14

64748

14

FP19

5

55489

1

62835

4

yl

Wednesday, January 05, 2011 12:51:25 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 05, 2011 12:51:25 PM

Work Order ID: 64980

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

Start Date: 1/5/2011

Required Date: 1/14/2011

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

110

Each

17.0000

1

1



Wearshoe



all 1/05/20

Location

Loc Qty

Loc Code

FG

1

364748

x1

34806

1

1367588

FP19

2

57525

1

58709

1

FP-19

14

62237

2

63575

12

D3566-1

Manufactured No

110

Each

18.0000

2

2



Gasket



all 1/05/20

Location

Loc Qty

Loc Code

FP015

18

B68924

x2

57715

2

61992

1

62892

3

63573

12

D3566-5

Manufactured No

110

Each

19.0000

1

1



Gasket



all 1/05/20

Location

Loc Qty

Loc Code

FP

12

B67584

x1

64789

12

FP015

7

63574

7

W/O:		WORK ORDER CHANGES					
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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

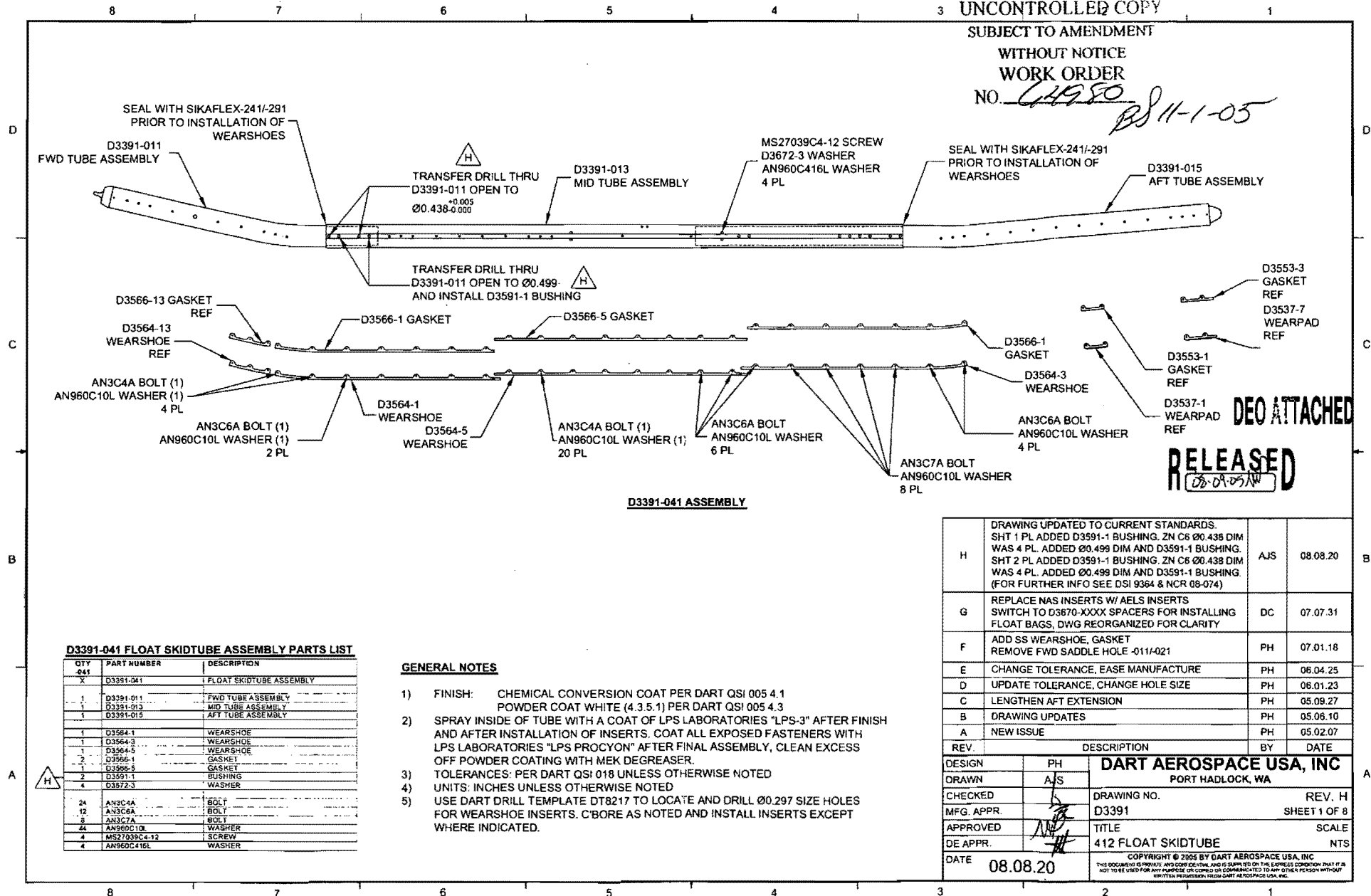
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 64950

BS11-1-05



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

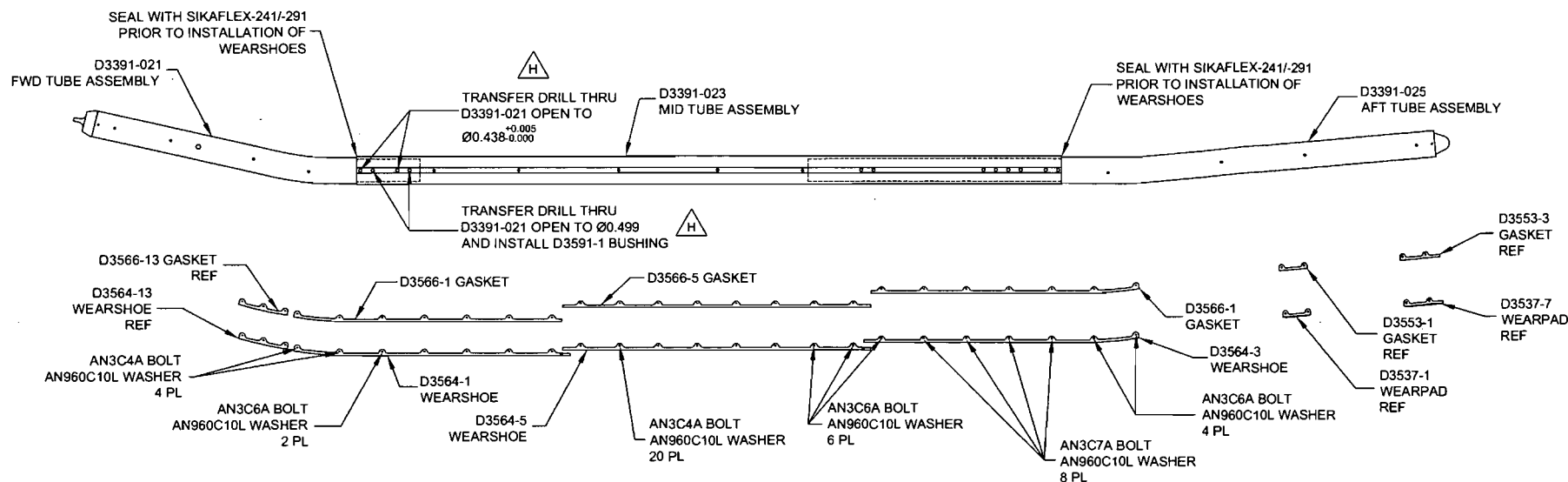
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W/064980



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

DEO ATTACHED

RELEASED
08-09-25/10

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	h	DRAWING NO.	REV. H
MFG. APPR.	h	D3391	SHEET 2 OF 8
APPROVED	h	TITLE	SCALE
DE APPR.	h	412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	<small> COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. </small>	

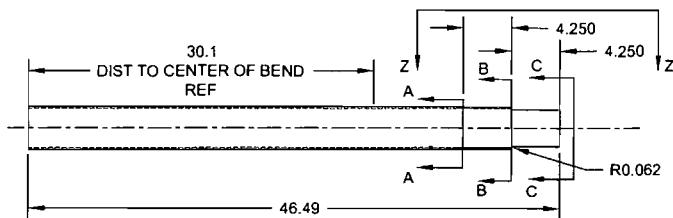
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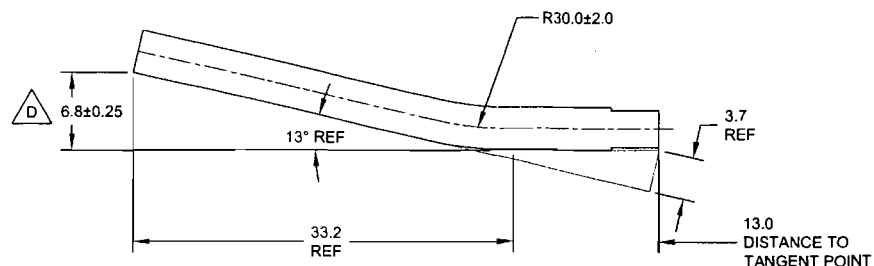
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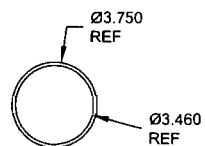
NOTE: Date & initial all entries



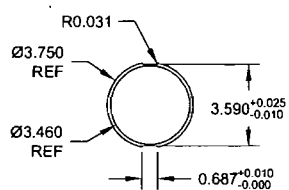
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



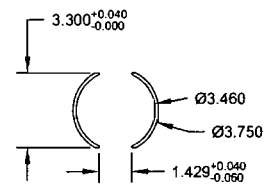
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



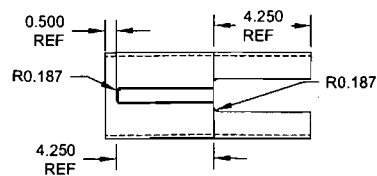
SECTION A-A
SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X



VIEW Z-Z
SCALE 2X

W/O 64980

DEO ATTACHED
RELEASED
08-05-11

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AUS	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3391	REV. H SHEET 3 OF 8
MFG. APPR.		TITLE	SCALE
APPROVED		412 FLOAT SKIDTUBE	NTS
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.	
DATE	08.08.20	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR CORRED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

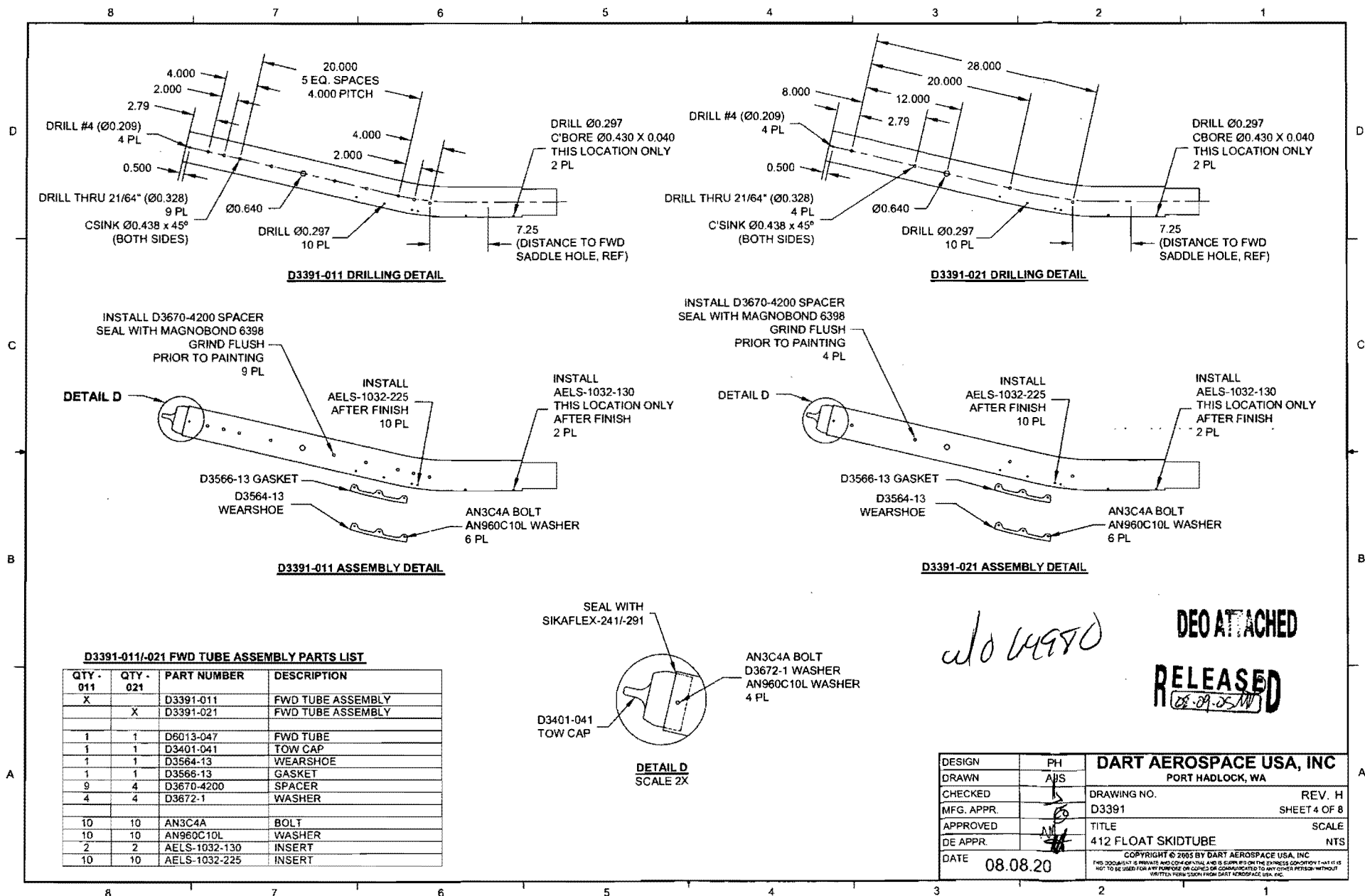
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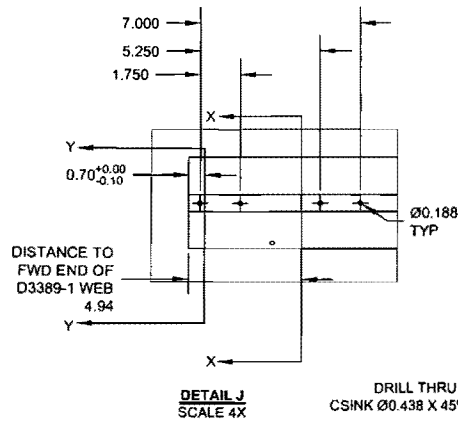
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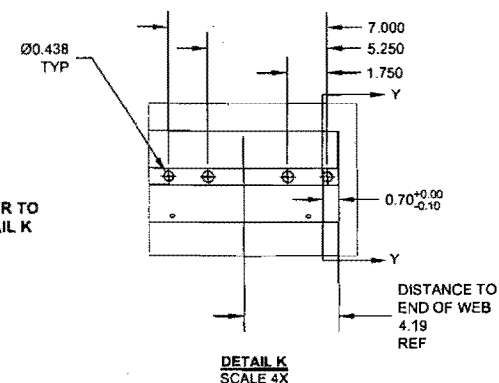
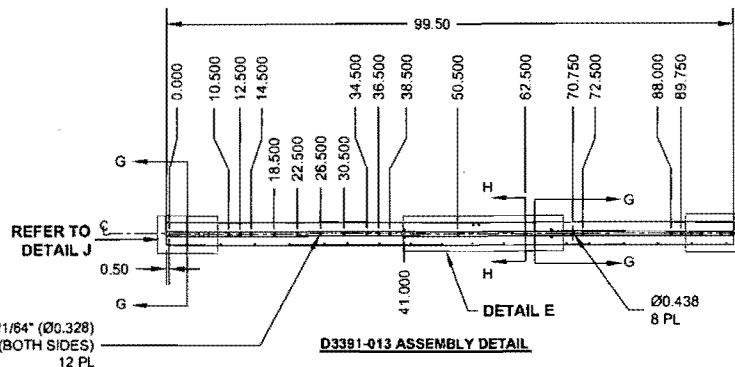
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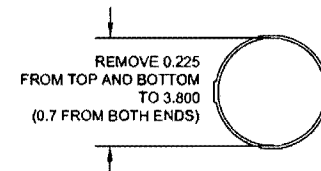
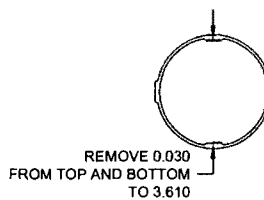
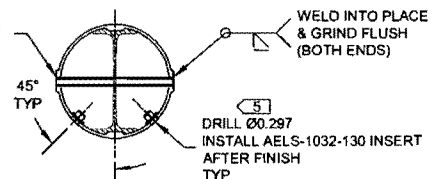
NOTE: Date & initial all entries



DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
12 PL



INSTALL
D3681-1 SPACER

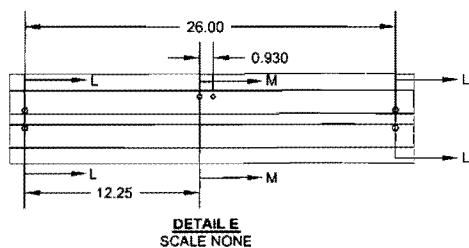


D3391-013 MID TUBE ASSEMBLY PARTS LIST

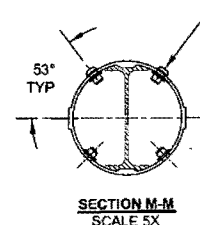
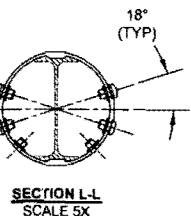
QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

D3391-013 MID TUBE ASSEMBLY

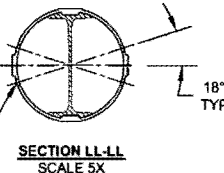
- MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-2411/291 PER QSI 015
- WELDING: PER DART QSI 004



DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN960C416L WASHER
AFTER FINISH
4 PL



DRILL Ø0.250
4 PL



DEO ATTACHED

RELEASED

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEETS OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
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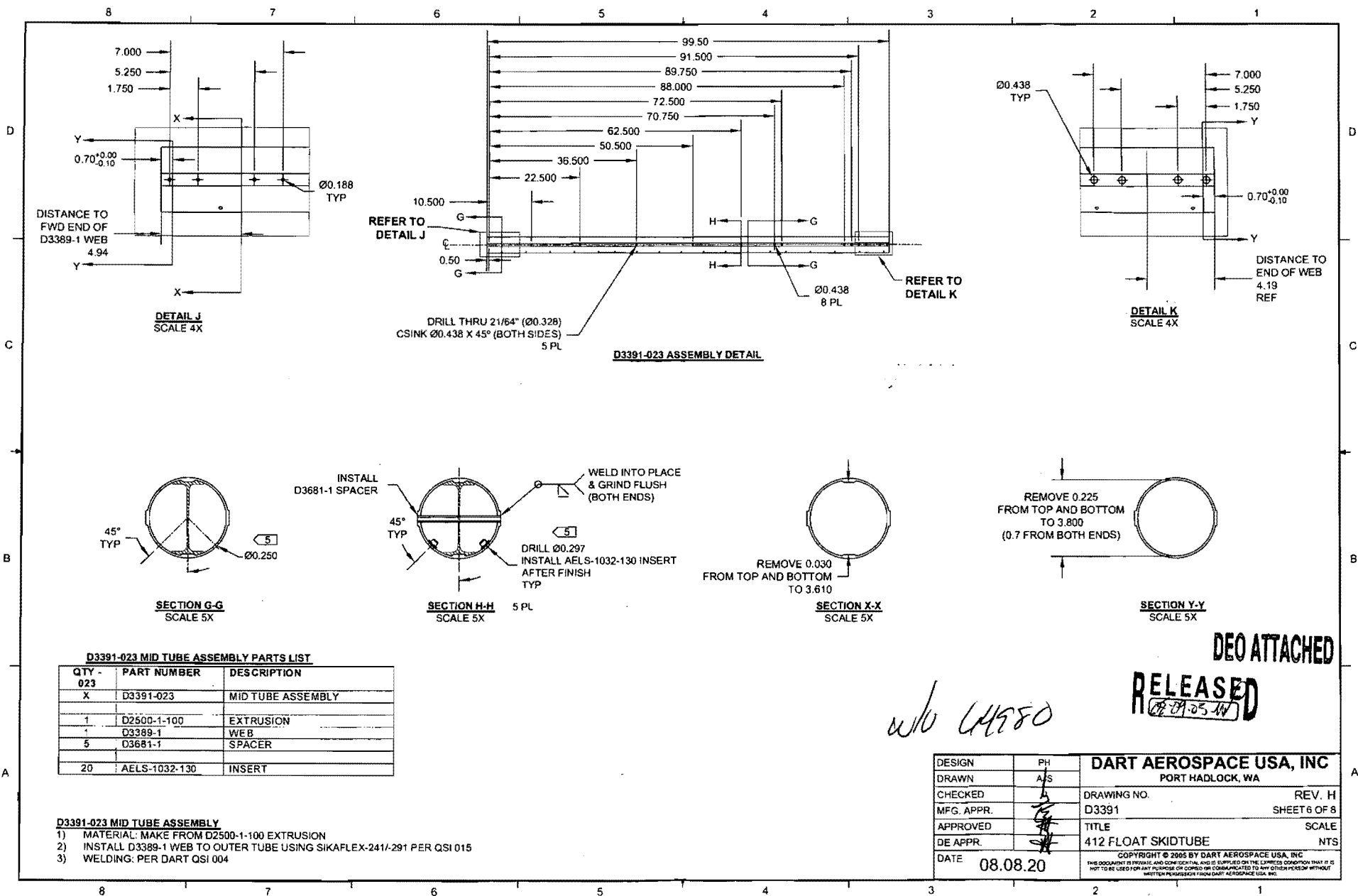
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



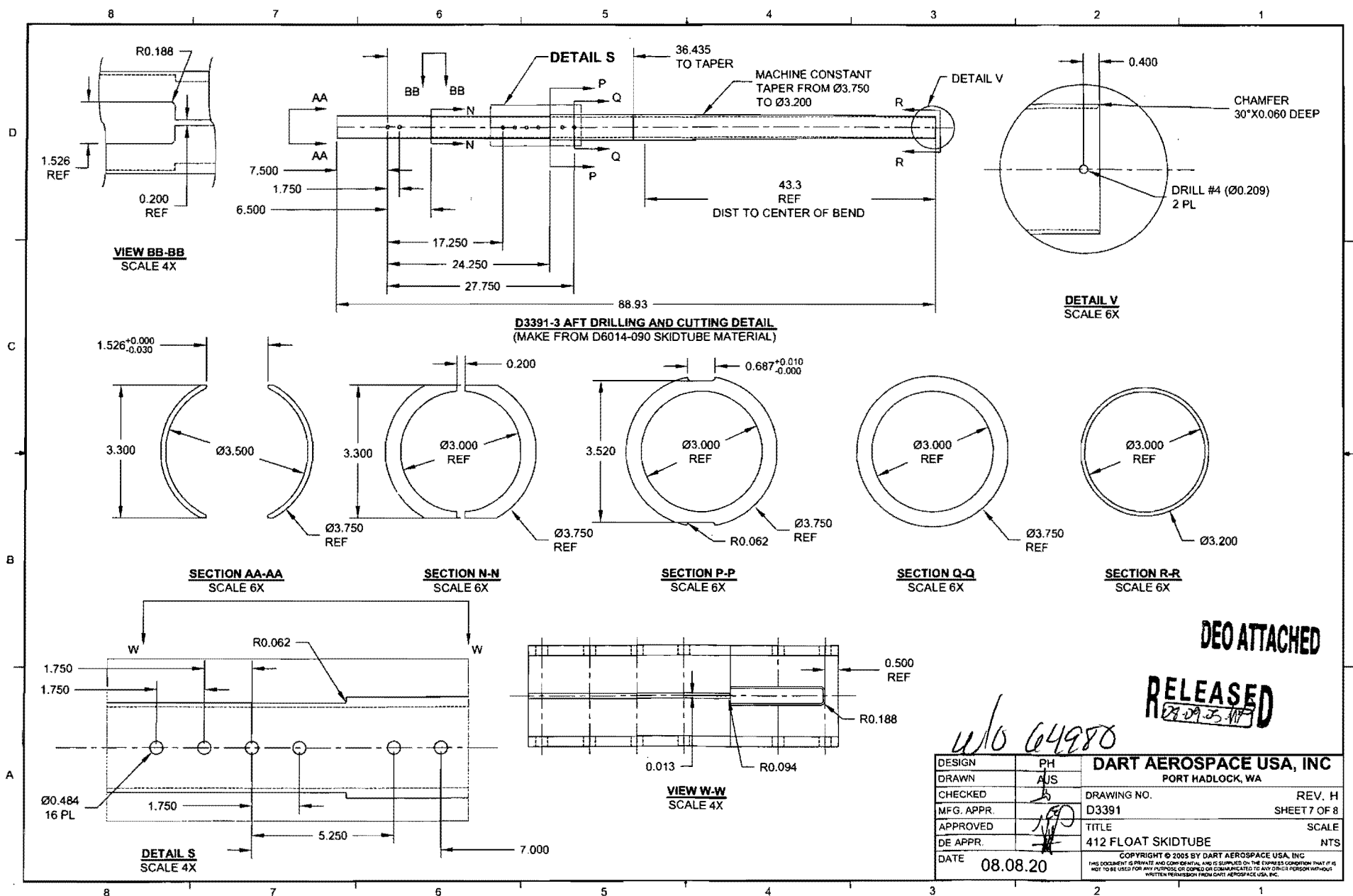
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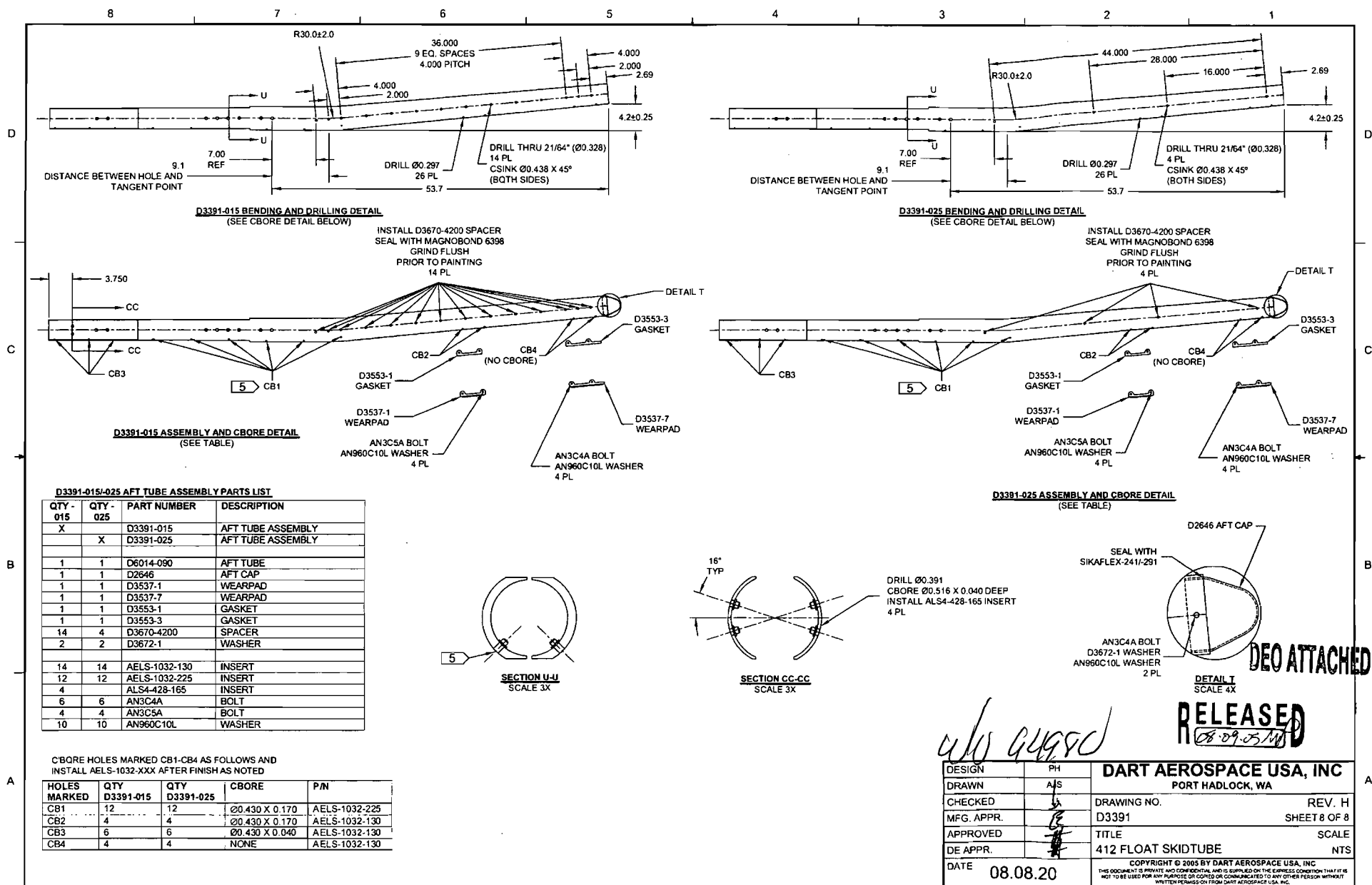
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DRAWING NO. D3391	TITLE 412 FLOAT SKIDTUBE	REV. H	DART AEROSPACE USA, INC ENGINEERING ORDER		D.E.O. NO. D3391-H-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>h</i>	MFG. APPR. <i>h</i>	APPROVED <i>MP</i>	DE APPR. <i>h</i>			
DATE 09.09.23	DATE 04.09.24	DATE 09/09/25	DATE 09/09/30	DATE 09/09/30			

PURPOSE:

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

CHANGE:

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

- 2) ~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.~~ COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

RELEASED
2010-02-02

MP

wk 64980

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